

Work Order ID 75349

October-21-11 8:03:44 AM

75349

Page 1

Item ID: D350-636-016

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-10-20

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3492	C								
D4168	A								
IIN-D350-636	I								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-016 CHG 002

S u 11/1/25

CK for MSL 11/1/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr, section R-R								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R								
	5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168 Detail J								
	6- Drill pilot holes as per Dwg D4168 sheet 5 (D4168-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail K. ***SECOND SIDE***								
	8- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole								
	9- Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201 iplace per side and open holes of detail M section R-R to 0.500" as per dwg D4168								
	10- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004								
	A/R Aluminum Rod batch: <u>m118735</u>								

DL 11/4/15

BE11-11-15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Grind welds flush as per Dwg D4168

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D4168.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>119399</u> exp. date: <u>12/06/13</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: <u>M118735</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D4168								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 02/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D41.68

12- C'bore section CH-CH

13- Deburr holes

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING
HOLE IN TUBE *****

170

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Handwritten notes and signatures:

- DP 11-11-23
- PTO
- Signature: [illegible]

Sulu/24

Sulu/24

(46)

W/O:		75346 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D38-636-016 PAR #: _____ Fault Category: landing gear NCR: Yes No DQA: _____ Date: _____
skid tube
 Resolution: Re work Disposition: Re work QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/21		the 2th, 18th, + 25th ^{from AFT} are were counter bore ovalizes + elongates P.C.L.S.A. Operate Pushdown hard and pulser counter bore off.	CP 11.11.21 PS1642	Drill out + Remove all cross bolt spacer. weld in new D4170-1 B71844 Oh +3 A/2 118735 D4170-1	BE 11-11-23	11-11-24 Sul11/24 Sul11/24	CP 11.11.21 PS1642	S ul11/21
			CP 11.11.21	As per AS204 Grind welds Flush + Re counter bore + Deburr.	BE 11-11-23	11-11-24 Sul11/24	CP 11.11.21	S ul11/21

NOTE: Date & initial all entries

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October-21-11 8:03:44 AM

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N900040100

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Item Name: Skidtube STD w/ Training Wearplates, RH

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Start Date: 20/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								

1 BA 11-11-24

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:30								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 4:00								

NGM-11/11/24

210	QC3- Inspect Part Finish	0.00							
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210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

1 & 11/11/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-636-016 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube STD w/ Training Wearplates, RH
 Start Date: 20/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 02/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D4168								
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>1217</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168								
	SIKA FLEX 241								
	BATCH: <u>1119443</u>								
	EXP DATE: <u>1210</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>11103400</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>1114596</u>								

W/O:		WORK ORDER CHANGES					
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						D		

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October-21-11 8:03:44 AM

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Start Date: 20/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 02/11/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Sulul/25			(4)			
250 *250* Packaging Packaging	Pick Kit Memo If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1	0.00 0.00							11/11/25
260 *260* QC Quality Control	QC4- 100% Inspect kits for completeness Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00	Sulul/25			(4)			

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-016								
	Location: _____								
	PPP rev: <u>A</u>								
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

11/11/25

OK 11/11/25

11-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC
11.04.14 ecn11-553 DD verf:EC
per NCR 11-906 DD verf:EC

IPP Rev:B
IPP Rev:C 11.10.18 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3490-1		Manufactured	No			160	Each	42.0000	4	4			
D3490-1									**				
Cross Bolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				40					
				67773				5					
				71841				35					
				LG001				2					
				62450				2					
D3490-3		Manufactured	No			160	Each	42.0000	4	4			
D3490-3									**				
Cross Bolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				42					
				73295				42					
AN3C34A		Purchased	No			230	Each	66.0000	1	1			
AN3C34A									**				
BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST353				66					
				116075				42					
				117514				20					
				118838				4					

BE11-11-19
B76233 x4

BE11-11-19
B76234 x2

2 4

1111175

X

W/O:		WORK ORDER CHANGES					
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Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C36A Purchased No

230 Each 156.0000 4 4

AN3C36A

BOLT

**

11/11/25

Location

Loc Qty

Loc Code

FG

14

1118757

x4

101261

4

116590

10

ST353

142

116590

0

119083

12

119125

30

119324

100

AN3C37A

Purchased No

230 Each 139.0000 1

AN3C37A

BOLT

**

Location

Loc Qty

Loc Code

ST354

139

116874

11

117010

2

118518

51

118709

50

119324

25

AN3C42A

Purchased No

230 Each 45.0000 1

AN3C42A

BOLT

**

Location

Loc Qty

Loc Code

ST354

45

106176

2

117763

20

118131

20

118451

3

W/O:		WORK ORDER CHANGES					
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Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

18.0000

1

1

D3488-042

Blade Fitting Assembly, RH

**

u 11/25

Location

Loc Qty

Loc Code

FP008

18

62003

1

69904

6

71883

11

D3492-1

Manufactured No

230

Each

158.0000

8

8

D3492-1

Plug

**

u 11/25

Location

Loc Qty

Loc Code

FP

158

69531

8

73402

70

74444

80

D3492-3

Manufactured No

230

Each

117.0000

8

8

D3492-3

Plug

**

u 11/25

Location

Loc Qty

Loc Code

FP

117

71838

37

74447

80

D3873-1

Manufactured No

230

Each

356.0000

7

7

D3873-1

Bushing

**

u 11/25

Location

Loc Qty

Loc Code

ST088

356

64760

1

68247

4

73829

19

73831

332

B75481

x7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-21-11 8:03:48 AM

Work Order ID: 75349

75349

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4154-041 Manufactured No

230 Each 4.0000 1 1

D4154-041

Wearplate Assembly

**

11/11/25

Location

Loc Qty

Loc Code

FP

4

13 74074

X1

71442

4

D4170-1 Manufactured No

230 Each 36.0000 4 4

D4170-1

Bushing

**

BE 11-11-19

Location

Loc Qty

Loc Code

LG

32

68225

1

71844

31

4

LG002

4

65912

4

D4171-1 Manufactured No

230 Each 10.0000 1 1

D4171-1

Bushing

**

11/11/25

Location

Loc Qty

Loc Code

ST135

10

69037

10

X1

MS21043-3 Purchased No

230 Each 921.0000 4 4

MS21043-3

Nut

**

11/11/25

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

849

118077

1

118614

492

118686

356

X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 75349

75349

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0363R

Purchased

No

230

Each

3,939.000

9

9

NAS1149C0363R

Washer

**

ul ul ul 25

Location

Loc Qty

Loc Code

ST297

3939

114742

3939

99

NAS1515H3L

Purchased

No

230

Each

111.0000

4

4

***NAS1515H3I ***

WASHER

**

ul ul ul 25

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

71

113362

57

118686

14

x4

NAS1611-010

Purchased

No

230

Each

105.0000

8

8

NAS1611-010

O-RING

**

ul ul ul 25

Location

Loc Qty

Loc Code

FP

81

117460

8

118077

1

118612

72

FP-A

24

110915

14

119307

10

M119138

x8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist-Print

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Page 6

Work Order ID: 75349

75349

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

192.0000

8

8

NAS1611-013

O-RING

**

11/11/28

Location

Loc Qty

Loc Code

FP

55

11119623

x8

117291

2

117887

53

FP-A

137

116582

5

118384

32

119307

100

NAS1149D0863J

Purchased

No

250

Each

230.0000

2

2

NAS1149D0863.J

WASHER

**

11/11/25

Location

Loc Qty

Loc Code

ST298

230

118078

130

119307

100

2

D2744

Manufactured

No

110

Each

63.0000

1

1

D2744

Cap

**

BE11-11-15

Location

Loc Qty

Loc Code

LG002

13

62715

1

70881

12

WA

50

71861

50

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 75349

75349

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

41.0000

1

1

D2600-3-BENT

Extrusion Bent

**

Location

Loc Qty

Loc Code

LG

41

66875

8

73253

3

75021

10

75022

10

75023

10

D2743

Manufactured No

160

Each

201.0000

8

8

D2743

Crossbolt Spacer

**

Location

Loc Qty

Loc Code

LG

143

71839

79

73403

64

LG001

58

67766

4

68251

54

D2739

Manufactured No

160

Each

9.0000

1

1

D2739

350 I Beam

**

Location

Loc Qty

Loc Code

LG

9

72155

2

72156

3

72157

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-21-11 8:03:48 AM

Page 8

Work Order ID: 75349

75349

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

2,610.000

4

4

AI S4-1032-225

Insert

**

4 11/1/25

Location

Loc Qty

Loc Code

ST282

2610

108696

758

110768

62

118386

860

118966

930

XL

AN8C35A

Purchased

No

230

Each

113.0000

1

1

AN8C35A

BOLT

**

4 11/1/25

Location

Loc Qty

Loc Code

FP

77

117511

11

118286

66

FP-A

1

115960

1

ST345

34

117834

34

ST346

1

XL

114442

0

115188

0

115960

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 75349

75349

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

113.0000

4

4

AN6C44A

BOLT

**

11/11/25

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

111

118387

41

118985

40

119125

30

11/11/25

x 1

MS21083C8

Purchased

No

230

Each

92.0000

1

1

MS21083C8

NUT

**

11/11/25

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

6

118077

6

ST303

85

115884

0

118354

10

118614

50

119309

25

x 1

D3631-1

Manufactured

No

230

Each

107.0000

8

8

D3631-1

Washer

**

11/11/25

Location

Loc Qty

Loc Code

ST072

107

68062

107

1375548

x 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 75349

75349

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

230 Each 0.0000 4 4

***AN960C10I ***

washer

** 1119736 (x4) ul ulul25

D2745 Manufactured No

230 Each 165.0000 8 8

D2745

Bushing

** ul ulul28

Location

Loc Qty

Loc Code

FP-A

3

69529

3

ST021

162

71835

162

NAS1149C0832R Purchased No

230 Each 345.0000 1 1

NAS1149C0832R

WASHER

** ul ulul25

Location

Loc Qty

Loc Code

FP-B

17

114915

17

ST297

328

114915

328

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

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Work Order ID: 75349

75349

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

232.0000

4

4

AN3C6A

BOLT

**

11/11/25

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

231

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

176

✓4

MS21043-6

Purchased

No

230

Each

505.0000

4

4

MS21043-6

NUT

**

11/11/25

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

485

112314

275

117887

10

118384

200

X4

D3493-1

Manufactured

No

250

Each

55.0000

2

2

D3493-1

Washer

**

11/11/25

Location

Loc Qty

Loc Code

ST062

55

70697

17

71846

38

2

October-21-11 8:03:48 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-21-11 8:03:48 AM

Page 12

Work Order ID: 75349

75349

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

92.0000

2

2

MS21083C8

NUT

**

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

6

118077

6

ST303

85

115884

0

118354

10

118614

50

119309

25

AN8C21A

Purchased

No

250

Each

69.0000

2

2

AN8C21A

BOLT

**

Location

Loc Qty

Loc Code

ST343

69

118045

19

118758

50

D2741

Manufactured

No

250

Each

19.0000

1

1

D2741

Blade, 350 Skidtube

**

Location

Loc Qty

Loc Code

ST466

19

70667

19

B75349 R+1

October-21-11 8:03:48 AM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1	1	1	D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75349

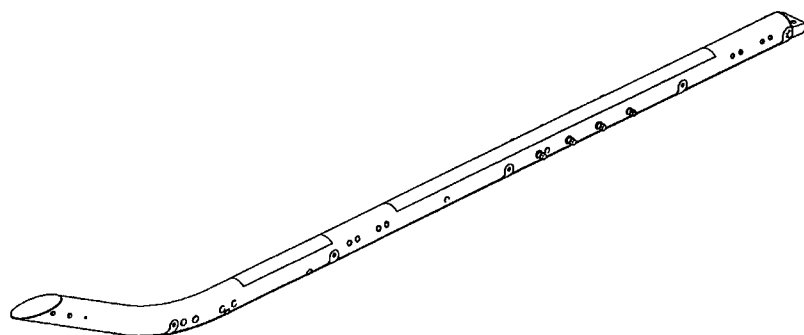
01110-21

GENERAL NOTES:

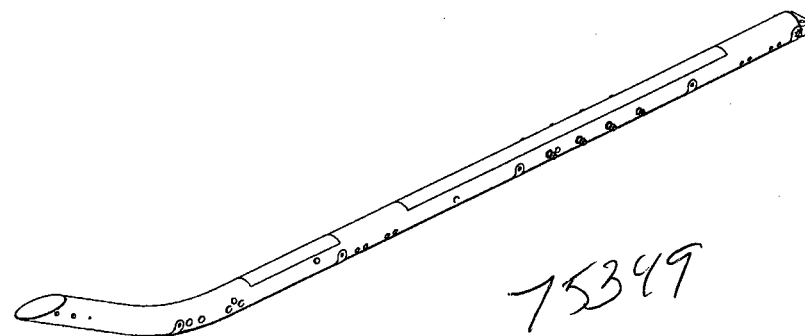
- 1) MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED
R 2010-09-15 D

A NEW ISSUE		SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



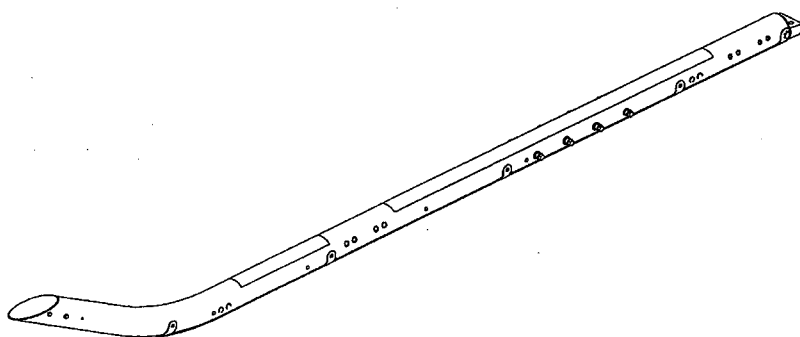
D4168-041 350 SKIDTUBE ASSEMBLY, LH



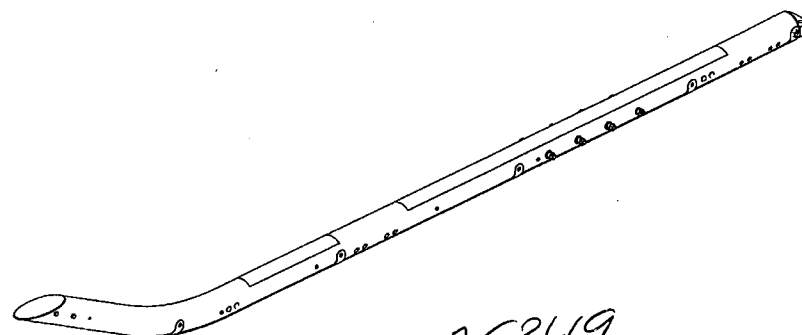
D4168-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2010-09-15
JW

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED IN THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



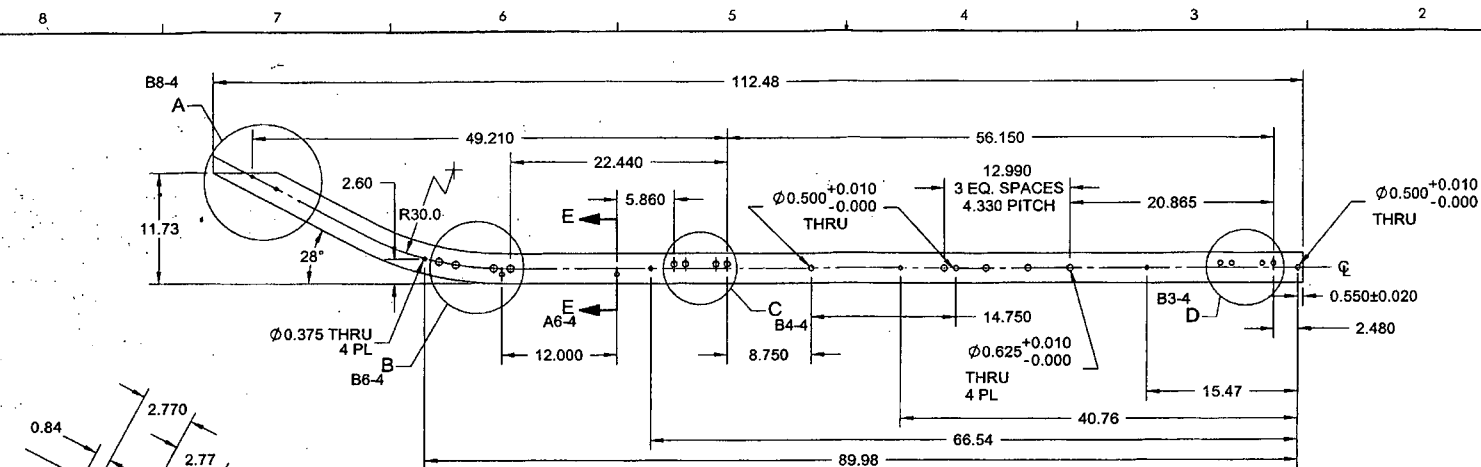
D4168-043 350 SKIDTUBE ASSEMBLY, LH



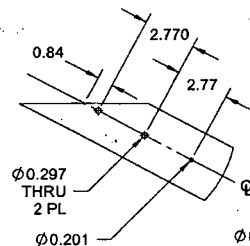
D4168-044 350 SKIDTUBE ASSEMBLY, RH

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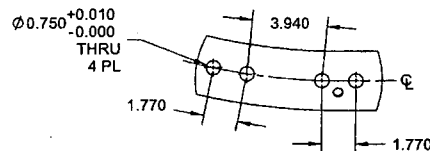
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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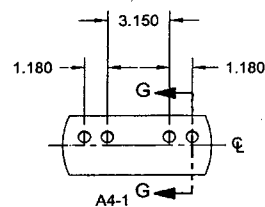
D4168-1 LH SKIDTUBE



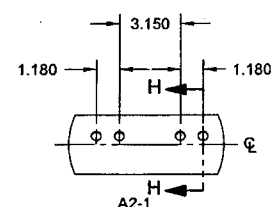
DETAIL A
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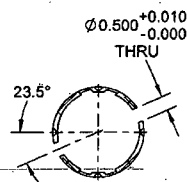
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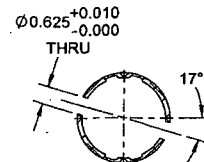
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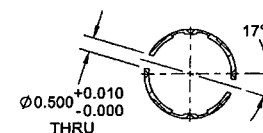
DETAIL D
SCALE 2X



SECTION E-E
SCALE 3X, 2 PL



SECTION G-G
SCALE 3X, 4 PL

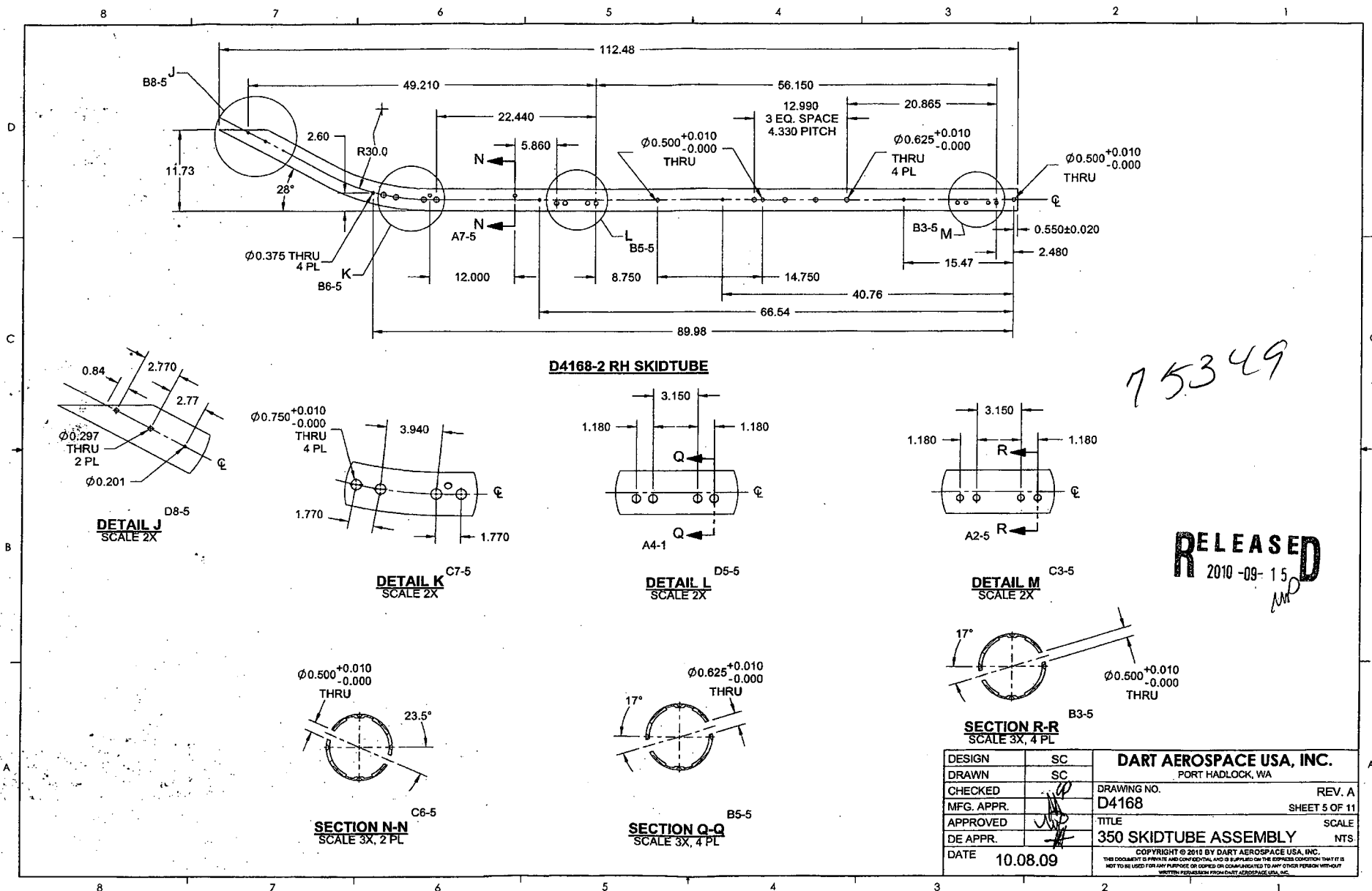


SECTION H-H
SCALE 3X, 4 PL

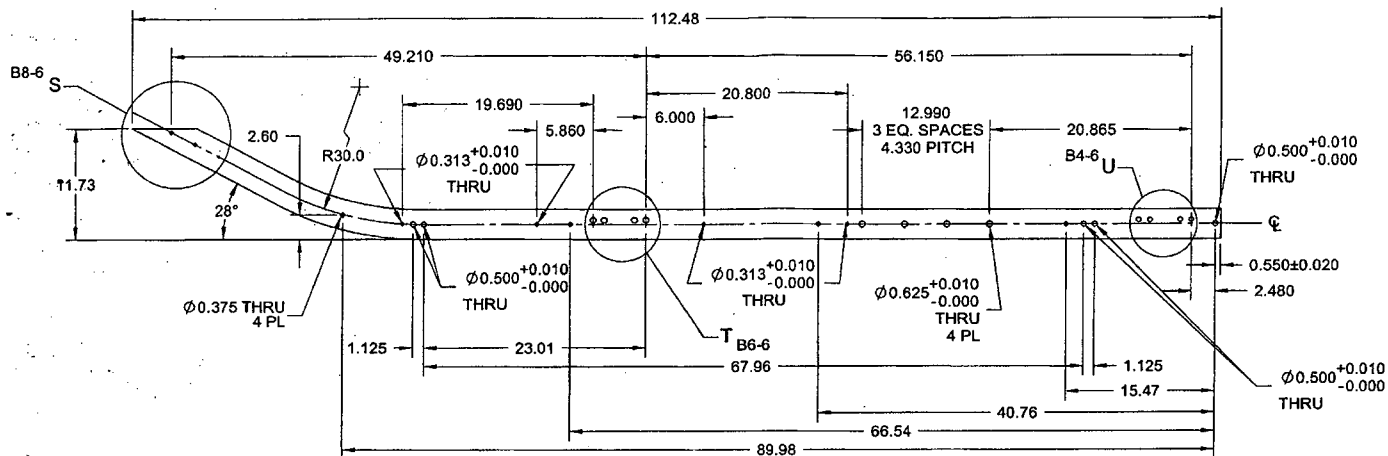
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2010-09-15

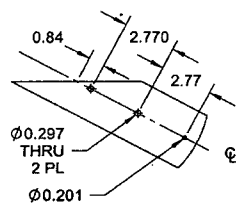
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CHECKED		SC	DRAWING NO.	REV. A
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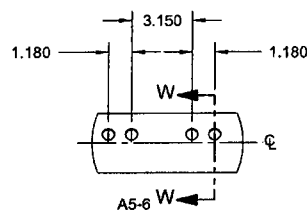
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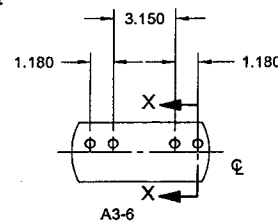
D4168-3 LH SKIDTUBE



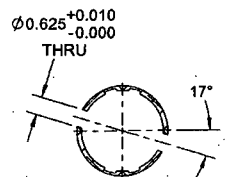
DETAIL S
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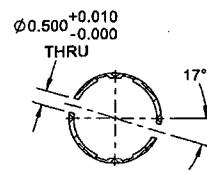
DETAIL T
SCALE 2X



DETAIL U
SCALE 2X



SECTION W-W
SCALE 3X, 4 PL



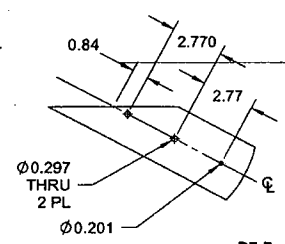
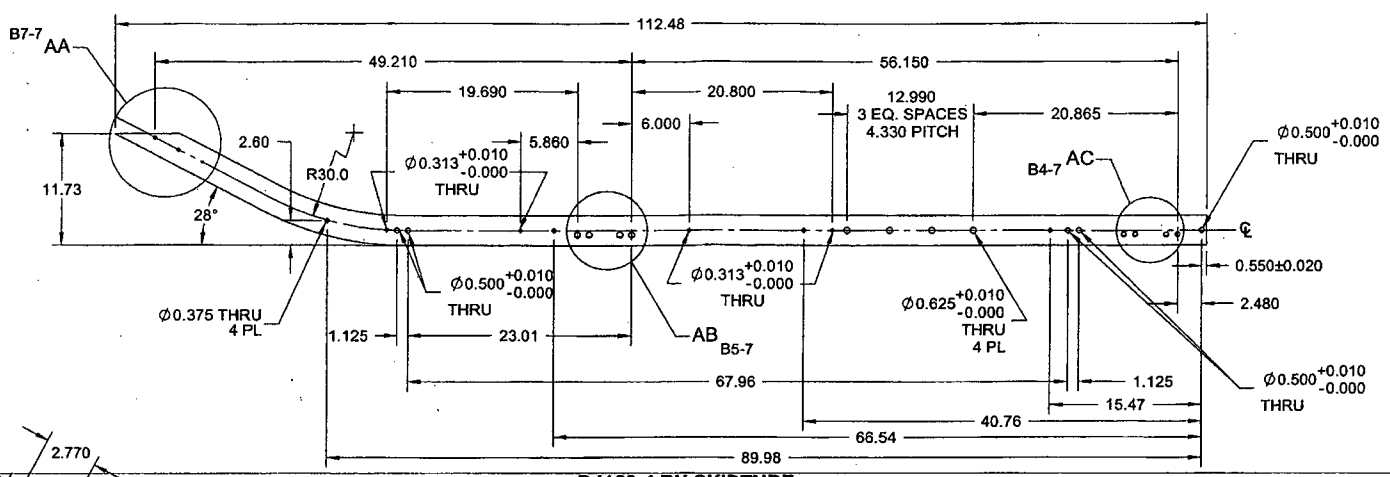
SECTION X-X
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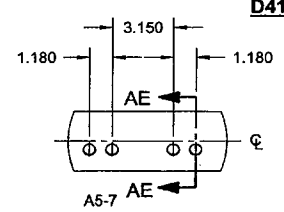
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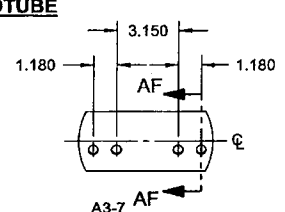
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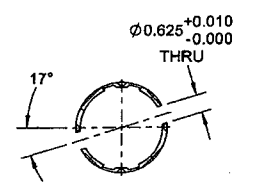
DETAIL AA
SCALE 2X



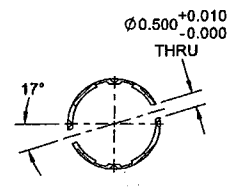
DETAIL AB
SCALE 2X



DETAIL AC
SCALE 2X



SECTION AE-AE
SCALE 3X, 4 PL



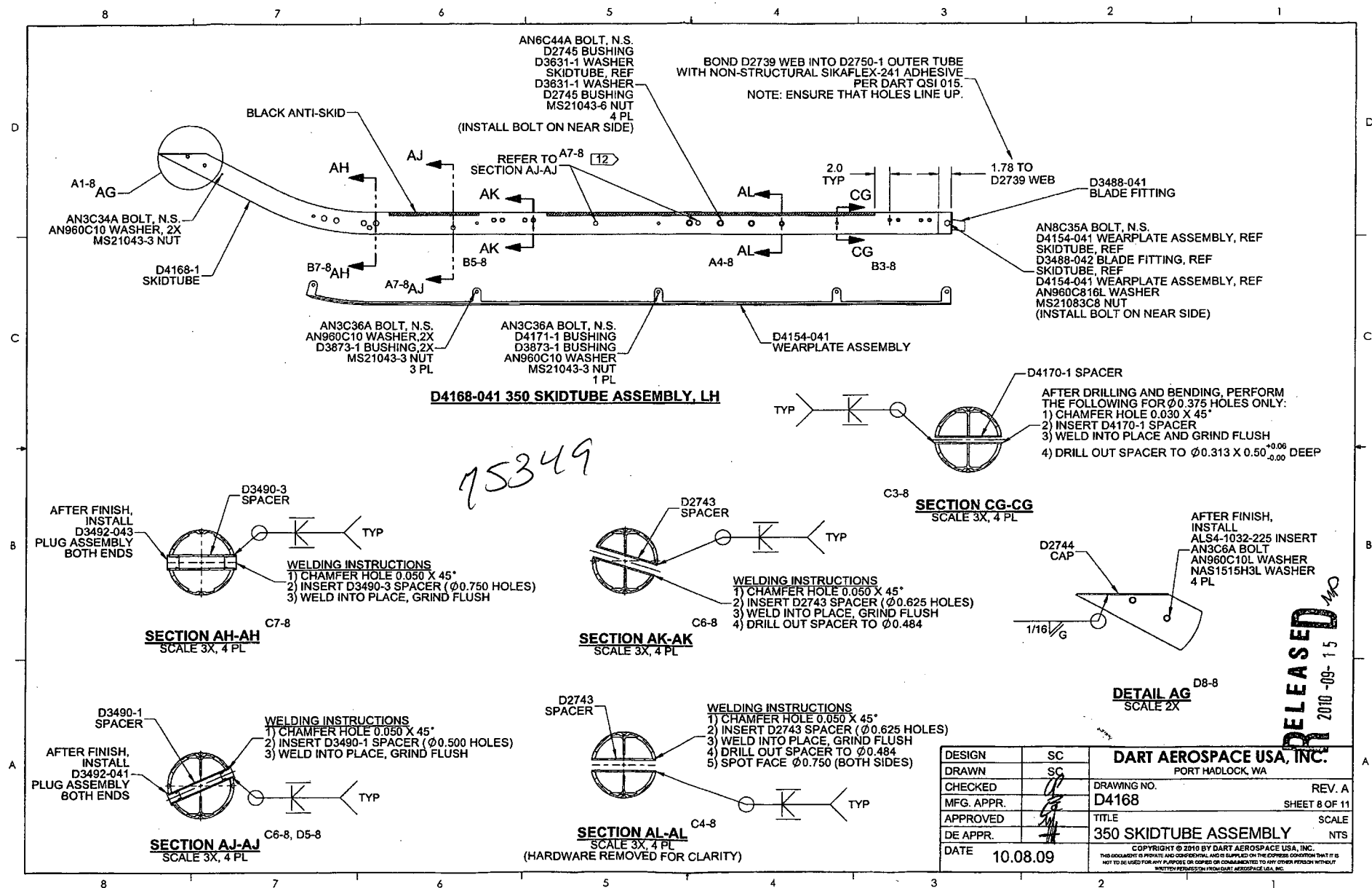
SECTION AF-AF
SCALE 3X, 4 PL

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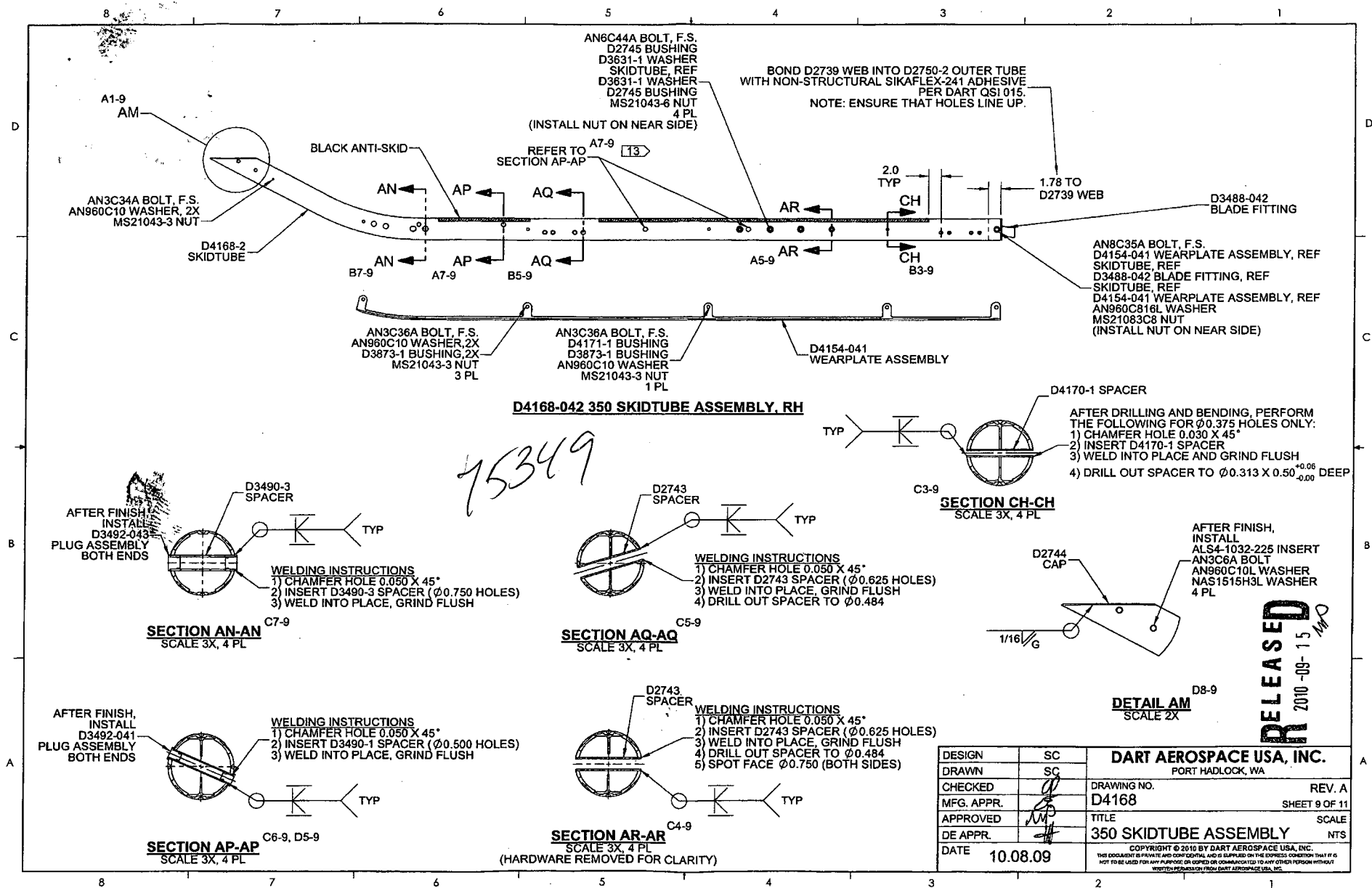
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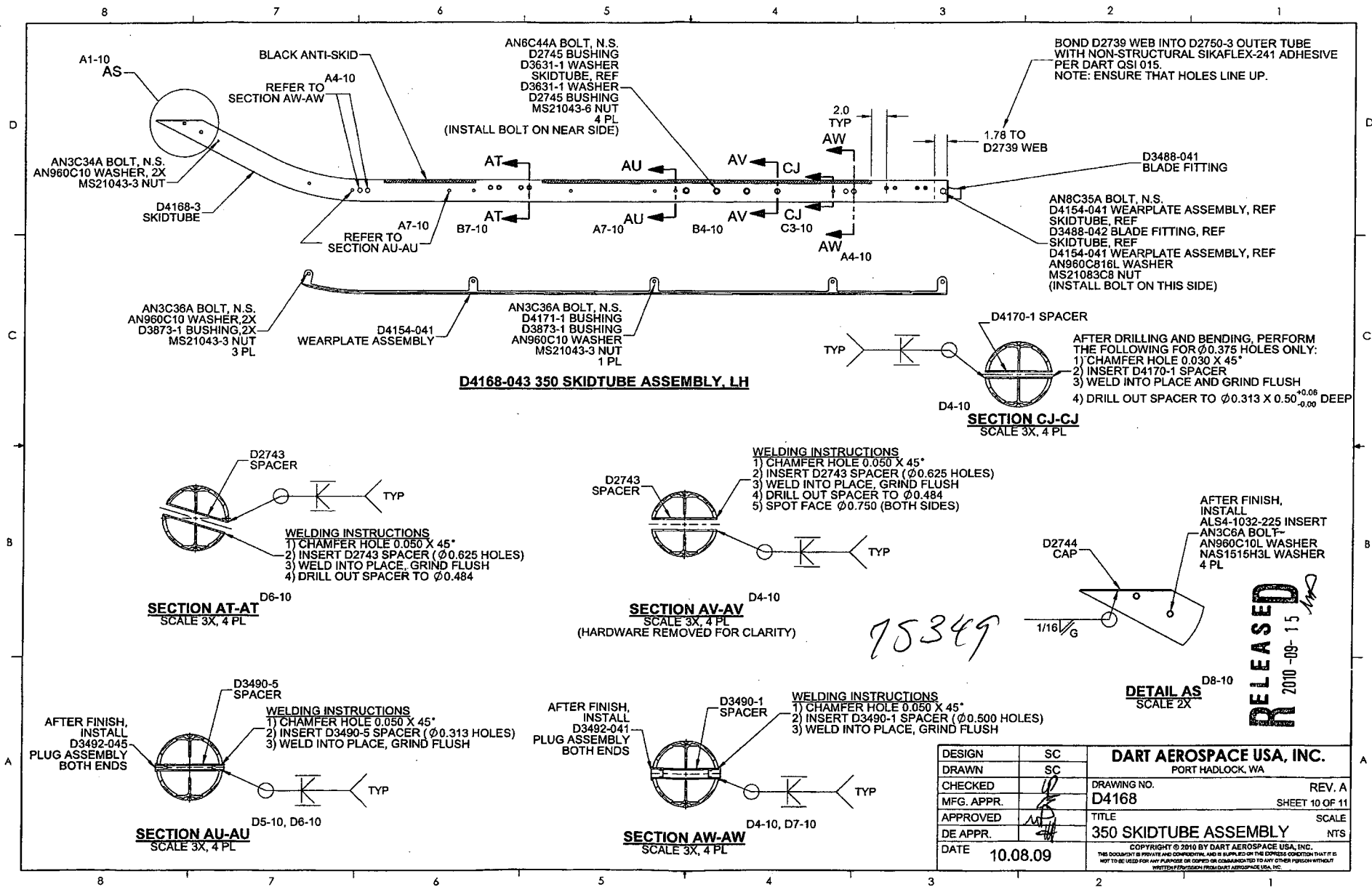
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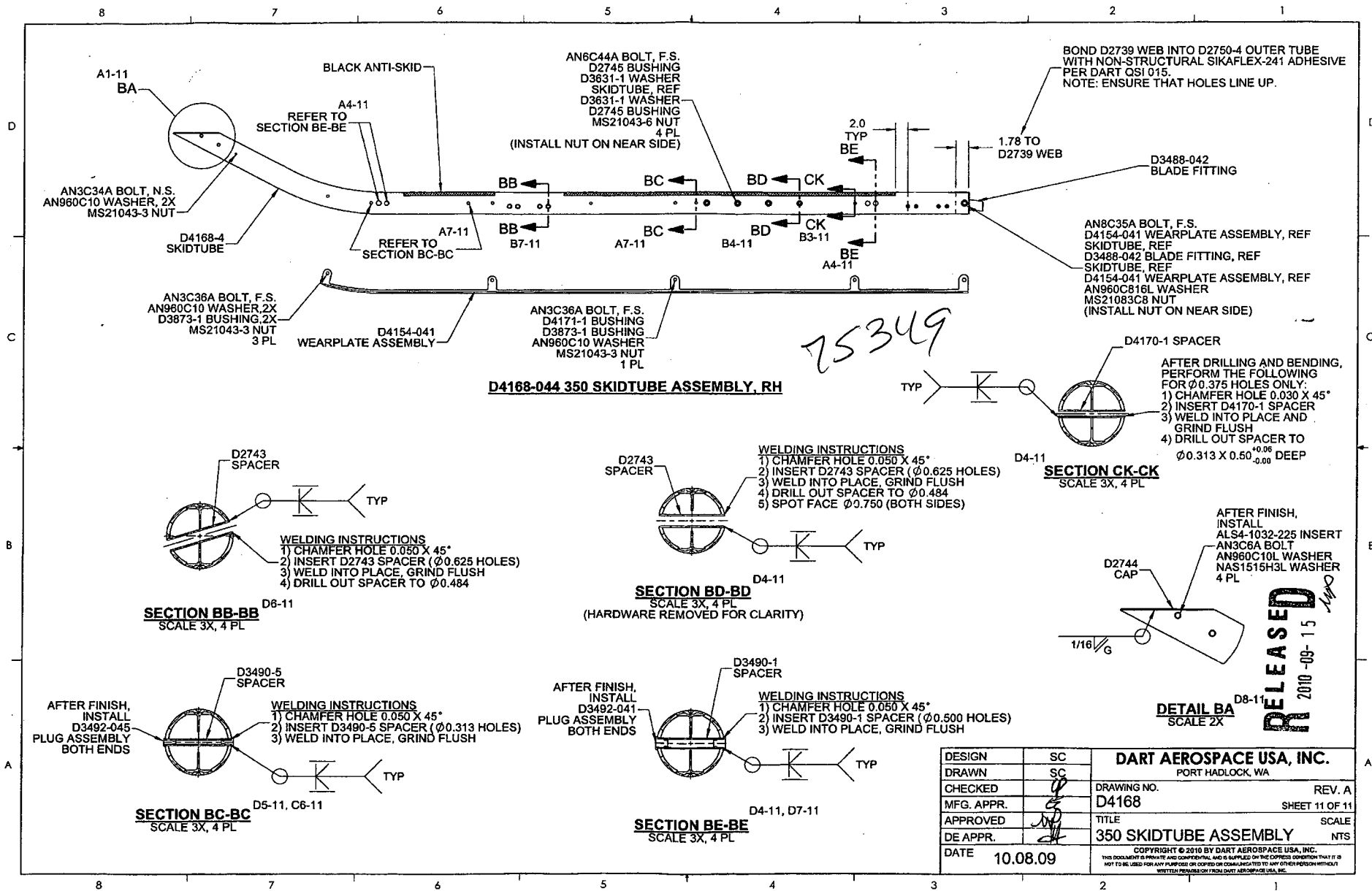


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2010-09-15



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2010-09-15





NO. 276

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 75349
Part number: 350-636-016
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David David Date of Test Coupon 11.11.22
Welder Barclay Elliot Date of Test Coupon 11.11.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld